

Work Order ID 80701

February-27-12 2:53:54 PM

80701

Page 1

Item ID: D4101-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pre-Flight Step Assembly
 Start Date: 27/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4101	B

100		0.00
100		
Small Fab	Memo	0.00
Small Fab	1- Assemble as per dwg	

Gx 0 SP 12-04-13

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

SP 12-04-13

(56)

120	Identify as per dwg & Stock Location: <u>8125</u>	0.00
120		
Packaging	Memo	0.00
Packaging		

(6x) SP 12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80701

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Item ID: D4101-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pre-Flight Step Assembly

Start Date: 27/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/4/17

R12-04-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 80701

80701

Parent Item: D4101-041

D4101-041

Parent Item Name: Pre-Flight Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.07 new issue DD verf:JLM
10.12.08 PER DWG REV.B DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4101-1		Manufactured	No			100	Each	1.0000	1	6			
D4101-1									**				
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
				61819				1					
D4101-3		Manufactured	No			100	Each	0.0000	1	6			
D4101-3													
Step													
D4101-5		Manufactured	No			100	Each	4.0000	1	6			
D4101-5									**				
Spring													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST126				4					
				61821				4					
AN4-22		Purchased	No			100	Each	35.0000	1	6			
AN4-22									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST359				35					
				115669				35					

Ep 12/04/12
B81945 (6x)

Ep 12/04/12
B81732 (6x) **

Ep 12/04/12
B81736 (4x)

Ep 12/04/12

6

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Parent Item: D4101-041

D4101-041

Parent Item Name: Pre-Flight Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0432J Purchased No
NAS1149D0432.J
 WASHER

100 Each 189.0000 2 12
 **

Location	Loc Qty	Loc Code
ST298	189	
116583	145	
116584	44	

EP 12/04/12

12

NAS1149D0463J Purchased No
NAS1149D0463.J
 Washer

100 Each 3,126.000 2 12
 **

Location	Loc Qty	Loc Code
ST298	3126	
116805	0	
117460	2	
118384	71	
118612	3	
119075	881	
119097	169	
120644	2000	

EP 12/04/12

1121011
 12x

AN310-4 Purchased No
AN310-4
 NUT

100 Each 56.0000 1 6
 **

Location	Loc Qty	Loc Code
ST344	56	
120124	31	
120518	25	

EP 12/04/12

1121011 (6x)

MS24665-136 Purchased No
MS24665-136
 Cotter Pins

100 Each 90.0000 1 6
 **

Location	Loc Qty	Loc Code
ST309	90	
2421	90	

EP 12/04/12

6

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Shop Packet Print

Page 2

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Parent Item: D4101-041

D4101-041

Parent Item Name: Pre-Flight Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 6.00

Required Qty: 6.00

AN525-832R6

Purchased

No

100

Each

511.0000

1

6

AN525-832R6

Screw

**

EP 12/04/12

Location

Loc Qty

Loc Code

ST345

511

120308

11

120560

500

MS21209C0815

Purchased

No

100

Each

92.0000

1

6

MS21209C0815

Heli Coil, screw locking, red

**

EP 12/04/12

Location

Loc Qty

Loc Code

ST304

92

118159

1

119316

91

6

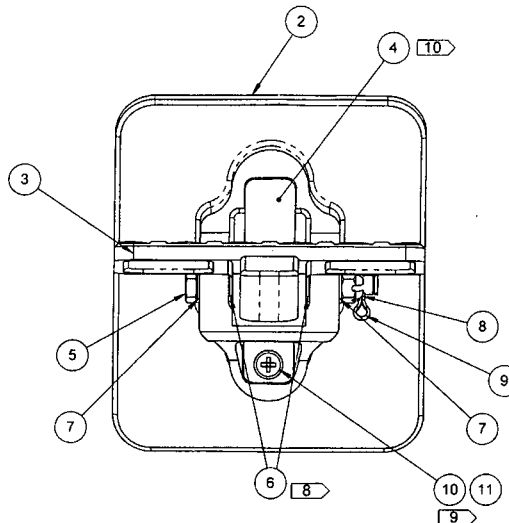
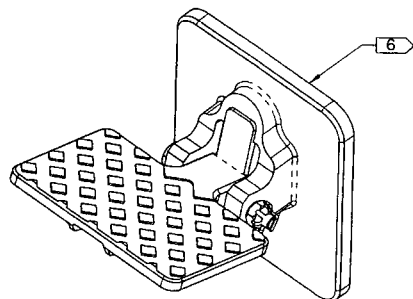
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D4101-041 PRE-FLIGHT STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
- 7) WEIGHT: 1.18 lbs
- 8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
- 9) TORQUE AN525832R SCREW TO 15-25 in-lb
- 10) TEXTURED SIDE TO BOTTOM

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL

80701 MJS
12/02/27

RELEASED
2010-08-23

B	NAS1149D0432J WAS NAS1149D0416J (ZN D3-1); ADD SCREW AND HELICOIL (ZN D3-1& B1-3); RE-DESIGN D4101-5 (ZN B4-5)		RF	10.08.05
A	NEW ISSUE		RF	10.07.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO. D4101 REV. B		
CHECKED	RF	SHEET 1 OF 5		
MFG. APPR.	RF	TITLE PRE-FLIGHT STEP ASSEMBLY SCALE NTS		
APPROVED	RF	DATE 10.08.05		
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NOTE: Date & initial all entries

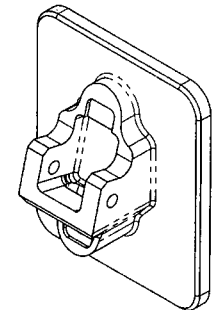
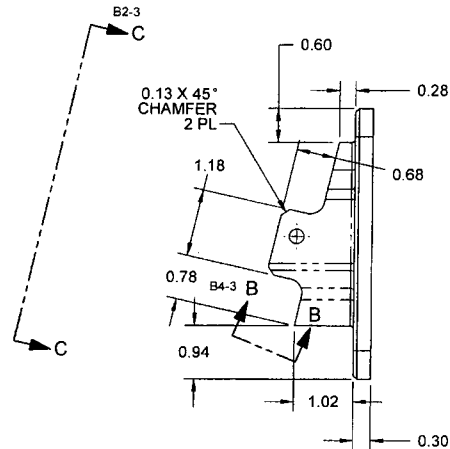
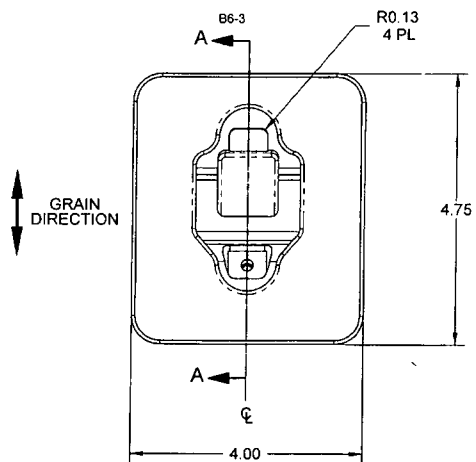
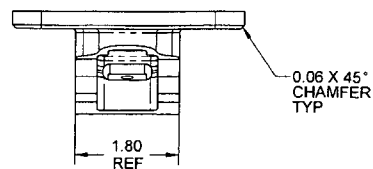
8 7 6 5 4 3 2 1

D

C

B

A



80701

D

C

B

A

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2010-08-23

D4101-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. B
MFG. APPR.	#	D4101	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

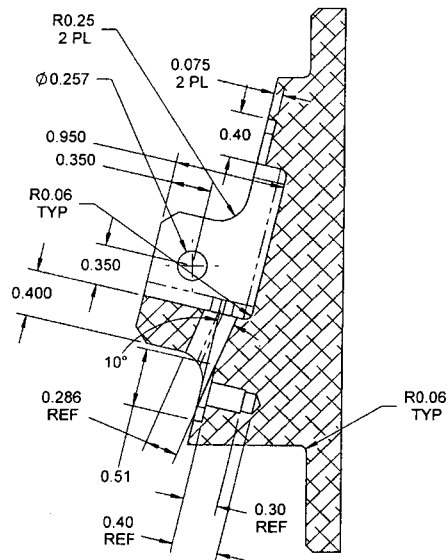
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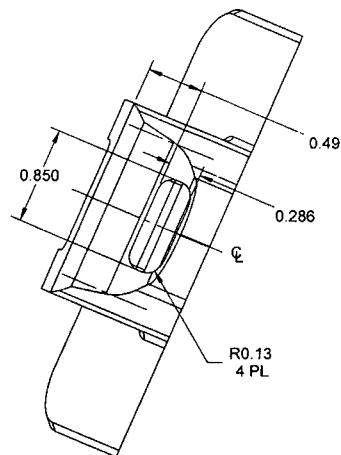
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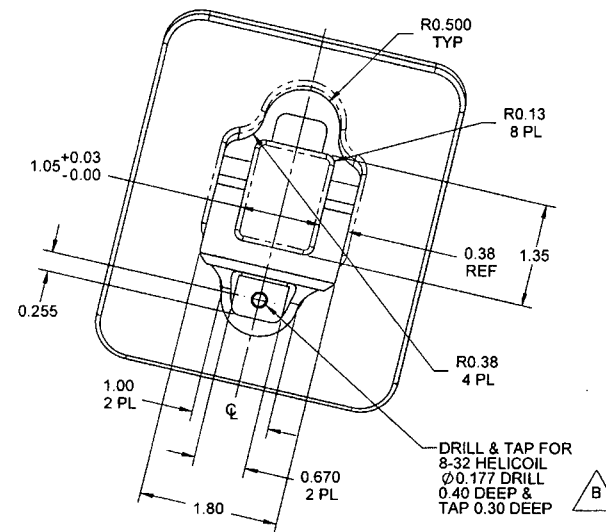
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SECTION A-A C7-2
SCALE 2X



VIEW B-B C4-2
SCALE 2X



VIEW C-C D4-2
SCALE X1.5

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2010-08-23

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4101	SHEET 3 OF 5
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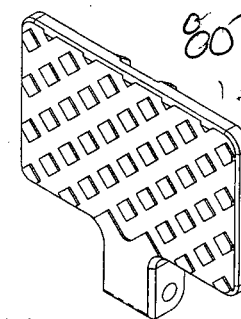
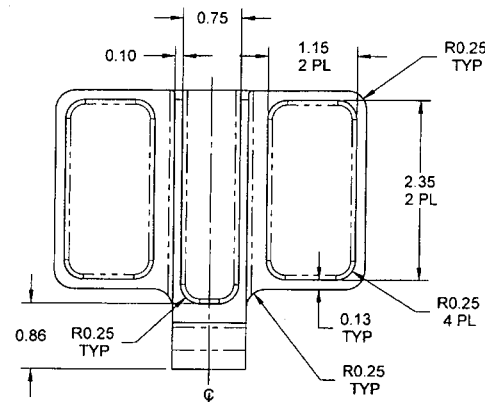
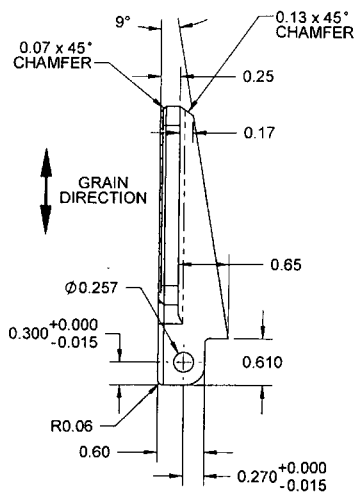
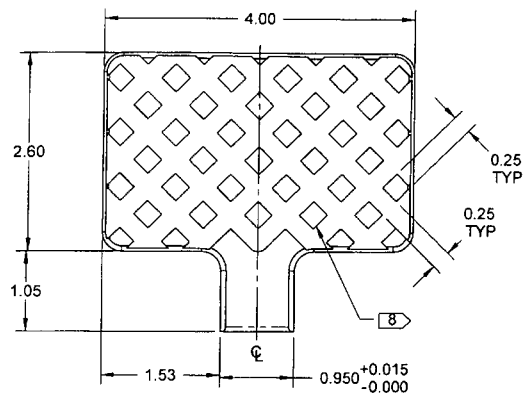
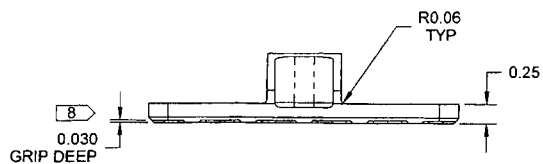
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NOTE: Date & initial all entries



D4101-3 STEP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) MACHINE 0.25 x 0.25 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

RELEASED
2010-08-23

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4101	SHEET 4 OF 5
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DE APPR.	<i>[Signature]</i>	PRE-FLIGHT STEP ASSEMBLY	
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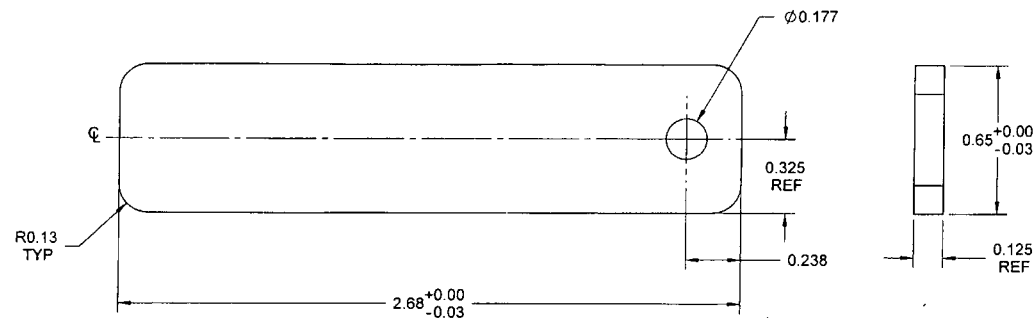
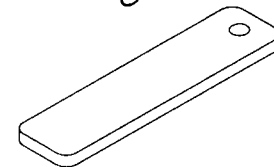
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80701



D4101-5 SPRING



RELEASED
2010-08-23

WPD

NOTES:

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D4101	SHEET 5 OF 5
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